

66794633

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 3518

BM FORM

proof of purchase



owner registration sticker



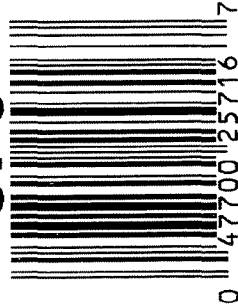
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6794633

UPC



GUN SERIAL #

G 679 4633

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-29-08	SPD
430	ASSEMBLE TO STOCK		9-29-08	SP
440	PROOF		9-29-08	SPD
460	CHECK HEADSPACE		9-29-08	SPD
470	DIS-ASSEMBLE ACTION		9-29-08	SPD
472	SERIALIZE BOLT HANDLE		9-30-08	BRN
475	DRILL AND TAP SIGHT HOLES		10/1/08	Fry
480	MAGNAFLUX BBL ACTION		10/2/08	SPD
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/2/08	RT
520	GOFF BLAST BBL / REC		10/4/08	DG
542	APPLY COATINGS (BARREL ACTION)		10-3	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-3-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-3-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-3-08	SP
	D) OIL FIRING PIN ASSEMBLY		10-14-08	BRN
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		
F004 REV 5/2006				

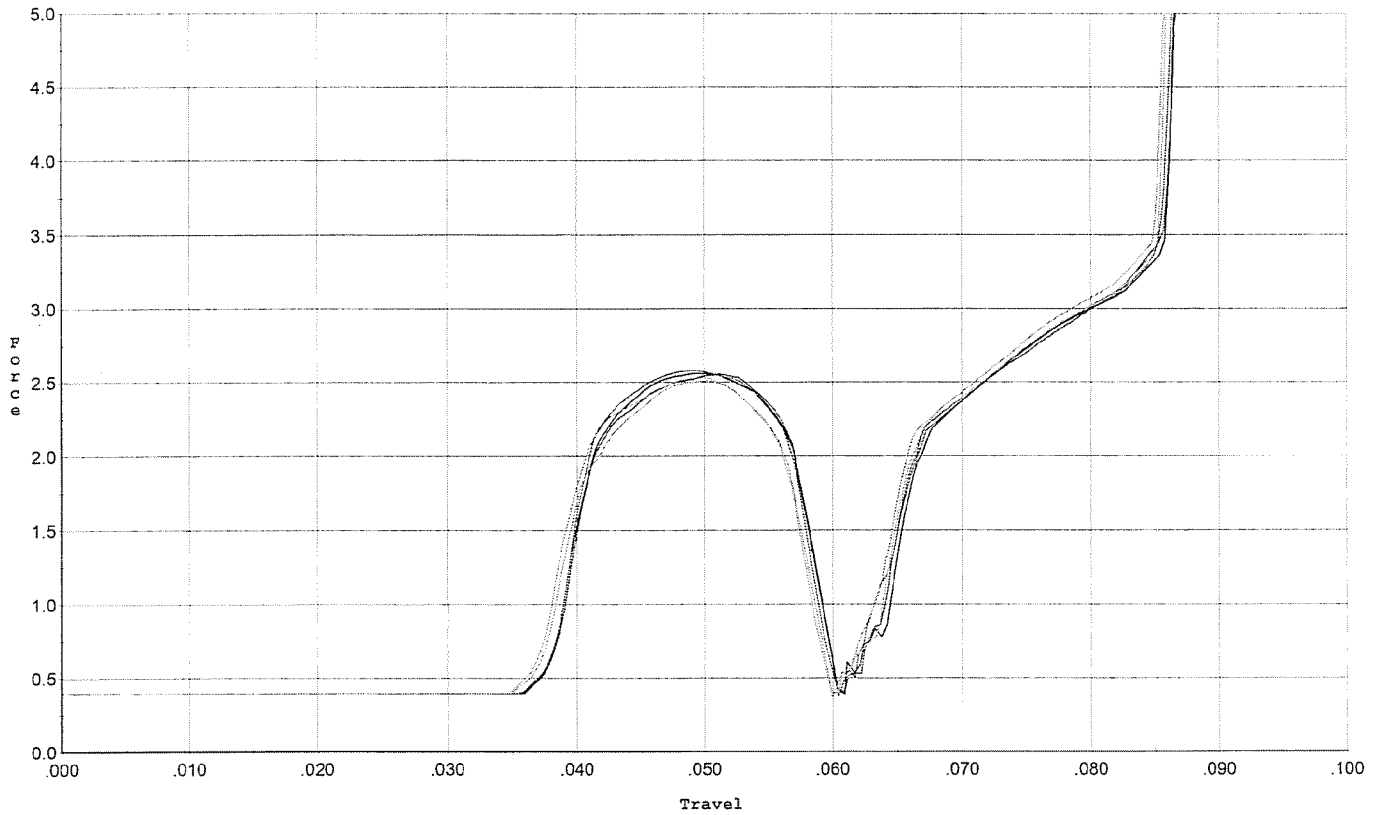
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>4.0</u> <u>4.0</u>	10-28-08	L.P.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>5.0</u> <u>5.0</u> <u>4.0</u>	10-28-08	L.N.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.024</u> <u>.024</u>	10-28-08	L.P.
	J) ASSEMBLE STOCK		10-14-08	FSN
	K) ASSEMBLE SWIVEL STUDS		10-28-08	L.N.
	L) ATTACH FRONT AND REAR SIGHT ASSY'S			
	M) IRON SIGHT ALIGNMENT			
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER			
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> <u>FAIL</u> <u>PASS</u> <u>FAIL</u>	10-23-08	FSN
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-23-08	TL
670	FINAL INSPECTION A) HEADSPACE		10-28-08	L.N.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.56</u> <u>2.64</u> <u>2.59</u> <u>2.61</u> <u>2.62</u>	10-28-08	L.P.
	C) FUNCTION		10-28-08	L.N.
690	PACK		11/4/08	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/13/08

Model: M/24
 Serial No: Form #F005
 Trigger: 2.5 lbs. ini. +/- .50 lbs.



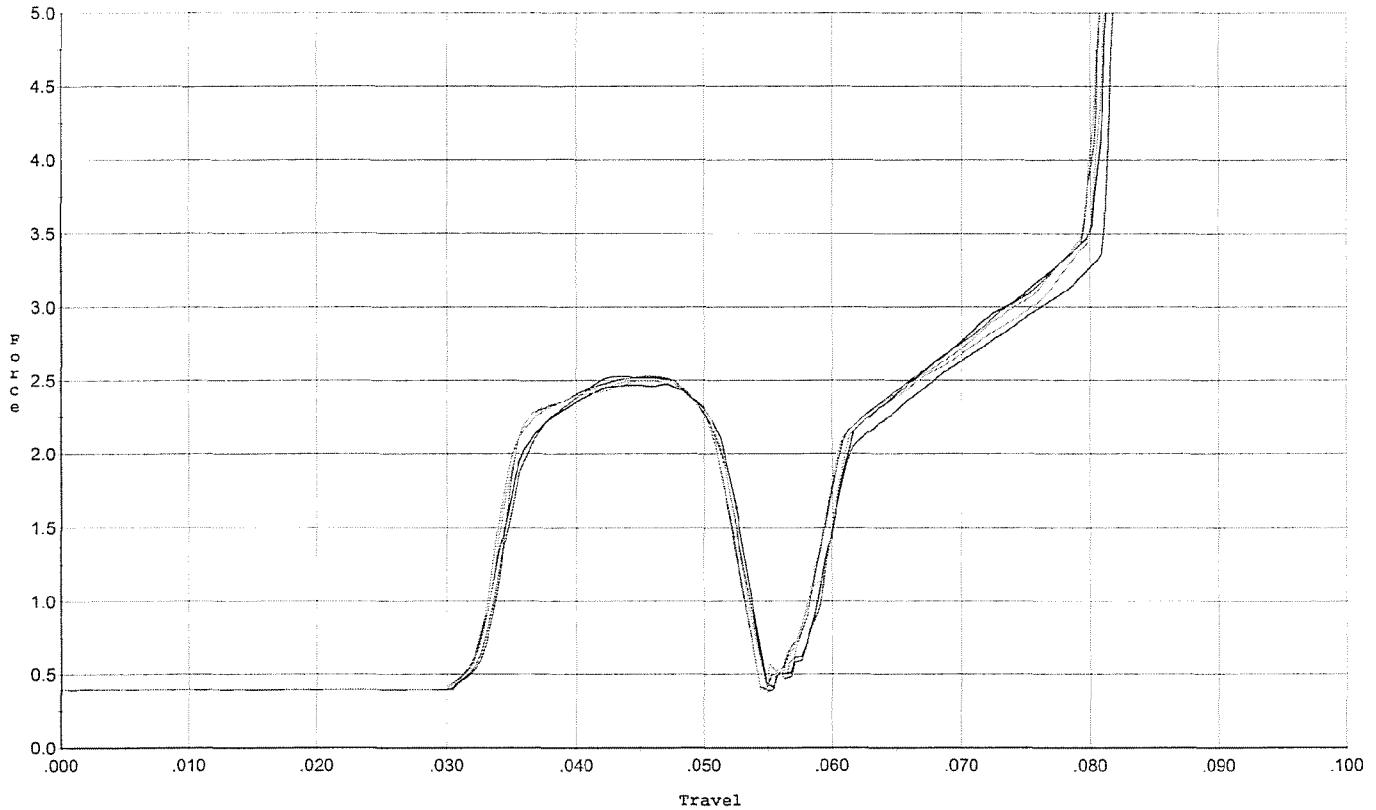
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.556	0.058	0.038	0.035	0.059		Set Trigger
2	2.559	0.058	0.038	0.035	0.060		Set Trigger
3	2.582	0.057	0.038	0.035	0.058		Set Trigger
4	2.512	0.057	0.037	0.035	0.057		Set Trigger
5	2.528	0.058	0.037	0.035	0.059		Set Trigger

Aug 2.54

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/13/08

Model: M/24
 Serial No: Form #F005
 Trigger: 2.5 lbs. after 50 cycles +/- .50 lbs.



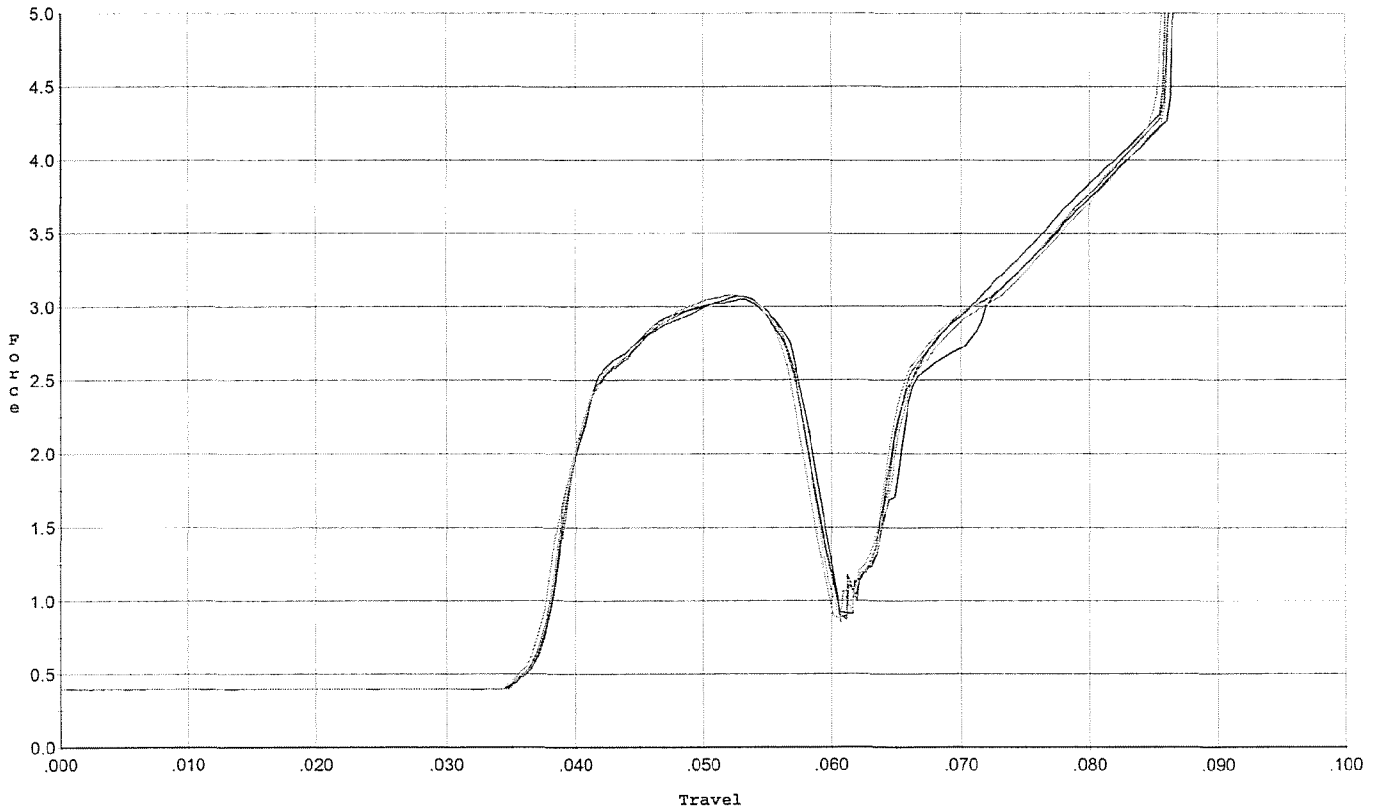
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.525	0.052	0.033	0.035	0.055		Set Trigger
2	2.471	0.053	0.032	0.034	0.056		Set Trigger
3	2.529	0.052	0.033	0.034	0.056		Set Trigger
4	2.505	0.051	0.032	0.034	0.056		Set Trigger
5	2.499	0.051	0.032	0.034	0.055		Set Trigger

Aug 2.50

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/13/08

Model: M/24
 Serial No: Form #F005
 Trigger: 3.0 lbs. ini. +/- .75 lbs.



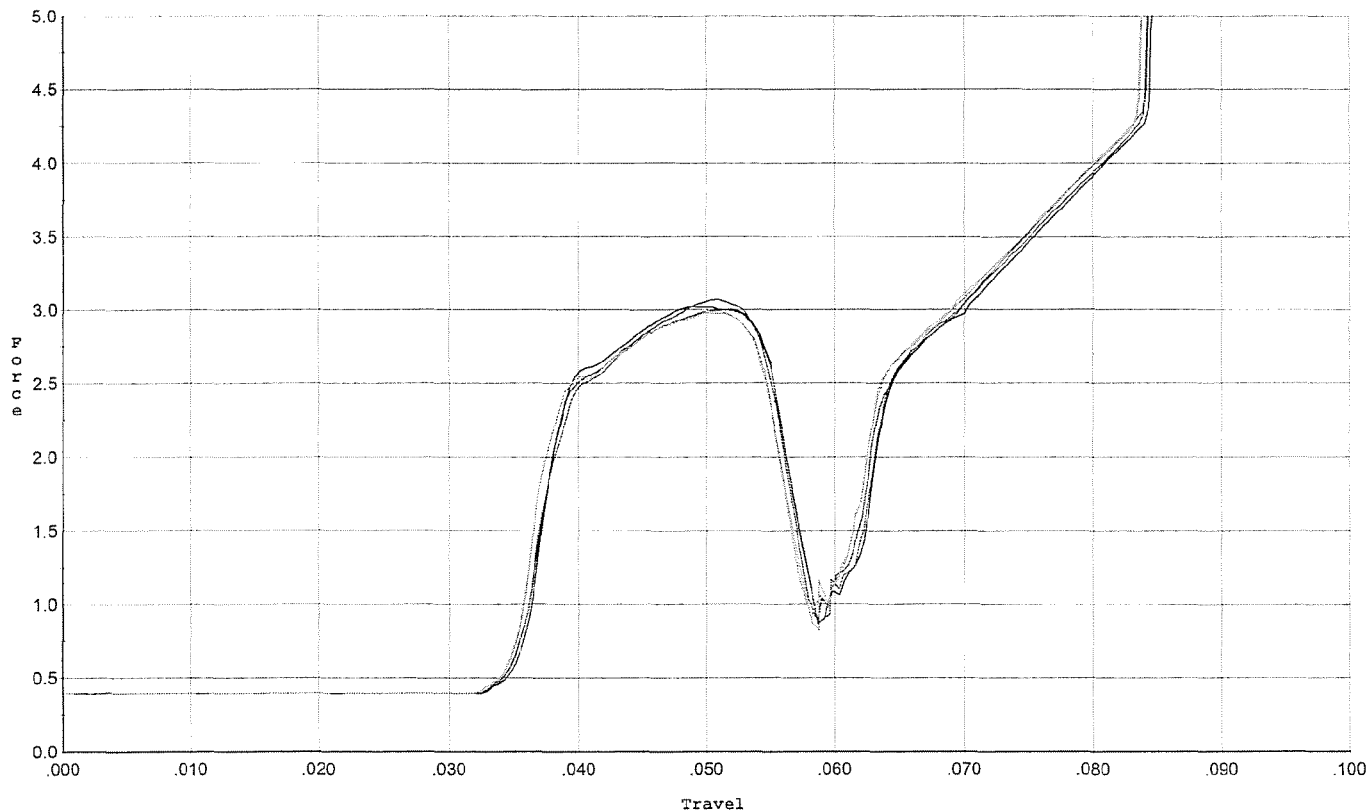
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.052	0.057	0.037	0.034	0.068		Set Trigger
2	3.073	0.058	0.037	0.034	0.070		Set Trigger
3	3.069	0.057	0.037	0.034	0.068		Set Trigger
4	3.081	0.057	0.037	0.034	0.067		Set Trigger
5	3.082	0.057	0.035	0.034	0.068		Set Trigger

Aug 3.07

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/13/08

Model: M/24
 Serial No: Form #F005
 Trigger: 3.0 lbs. after 20 cycles +/- .75 lbs.



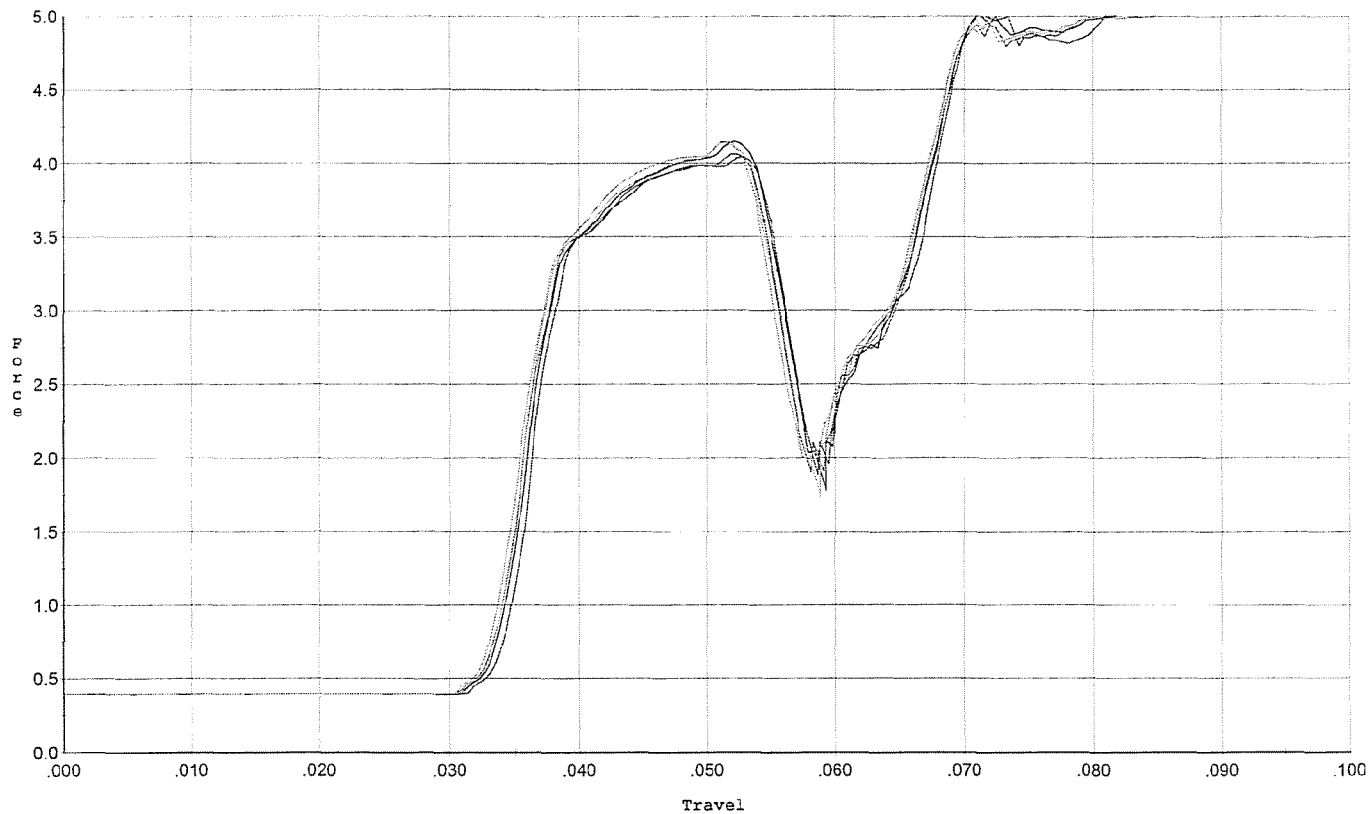
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.072	0.055	0.035	0.034	0.067		Set Trigger
2	3.023	0.055	0.035	0.035	0.066		Set Trigger
3	3.001	0.055	0.035	0.034	0.066		Set Trigger
4	2.977	0.055	0.035	0.034	0.065		Set Trigger
5	2.989	0.055	0.035	0.034	0.066		Set Trigger

Aug 3.01

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/13/08

Model: M/24
 Serial No: Form #F005
 Trigger: 4.0 lbs. ini. +/- 1.0 lbs.



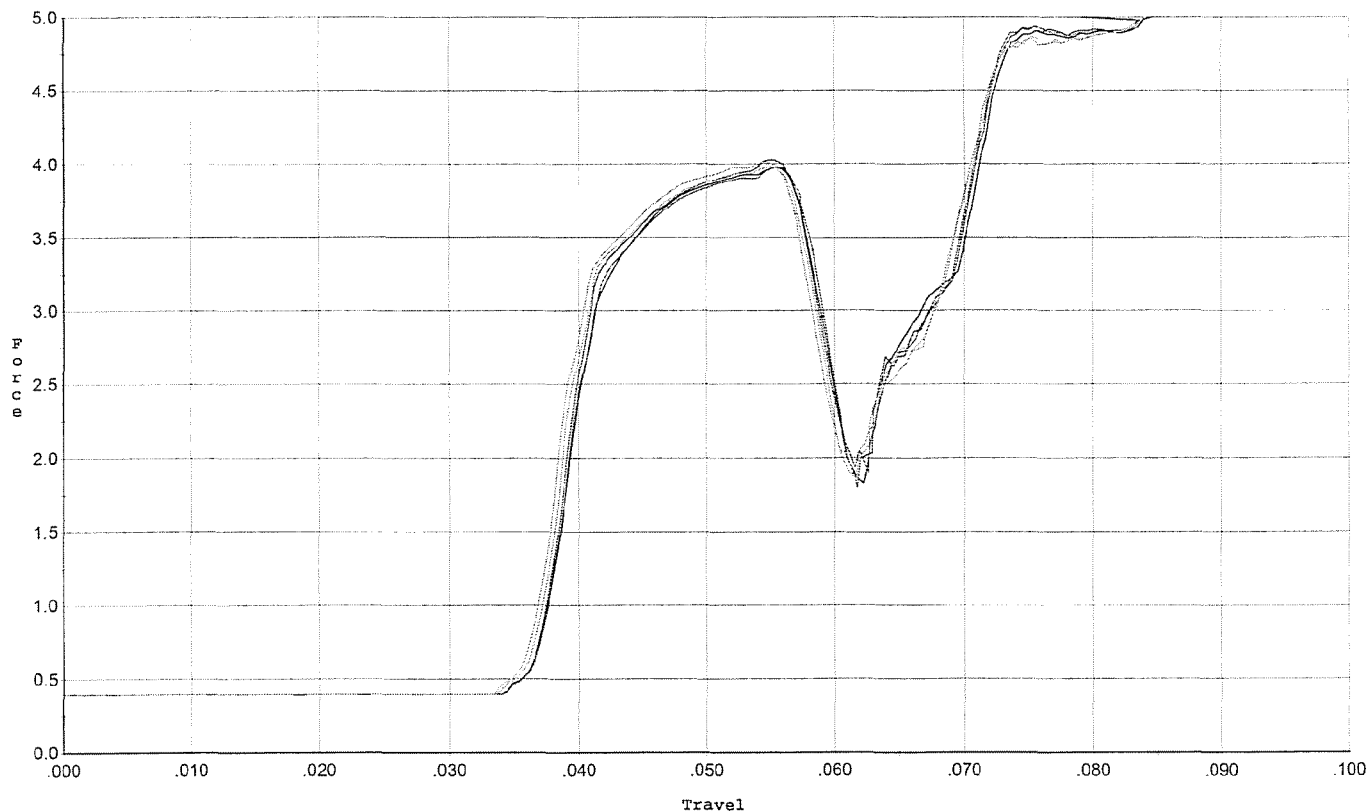
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.045	0.055	0.034	0.032	0.088		Set Trigger
2	4.151	0.056	0.033	0.032	0.090		Set Trigger
3	4.061	0.055	0.033	0.032	0.088		Set Trigger
4	4.146	0.055	0.033	0.032	0.089		Set Trigger
5	4.150	0.054	0.033	0.032	0.087		Set Trigger

AUG 4.11

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/13/08

Model: M/24
 Serial No: Form #F005
 Trigger: 4.0 lbs. after 20 cycles +/- 1.0 lbs.



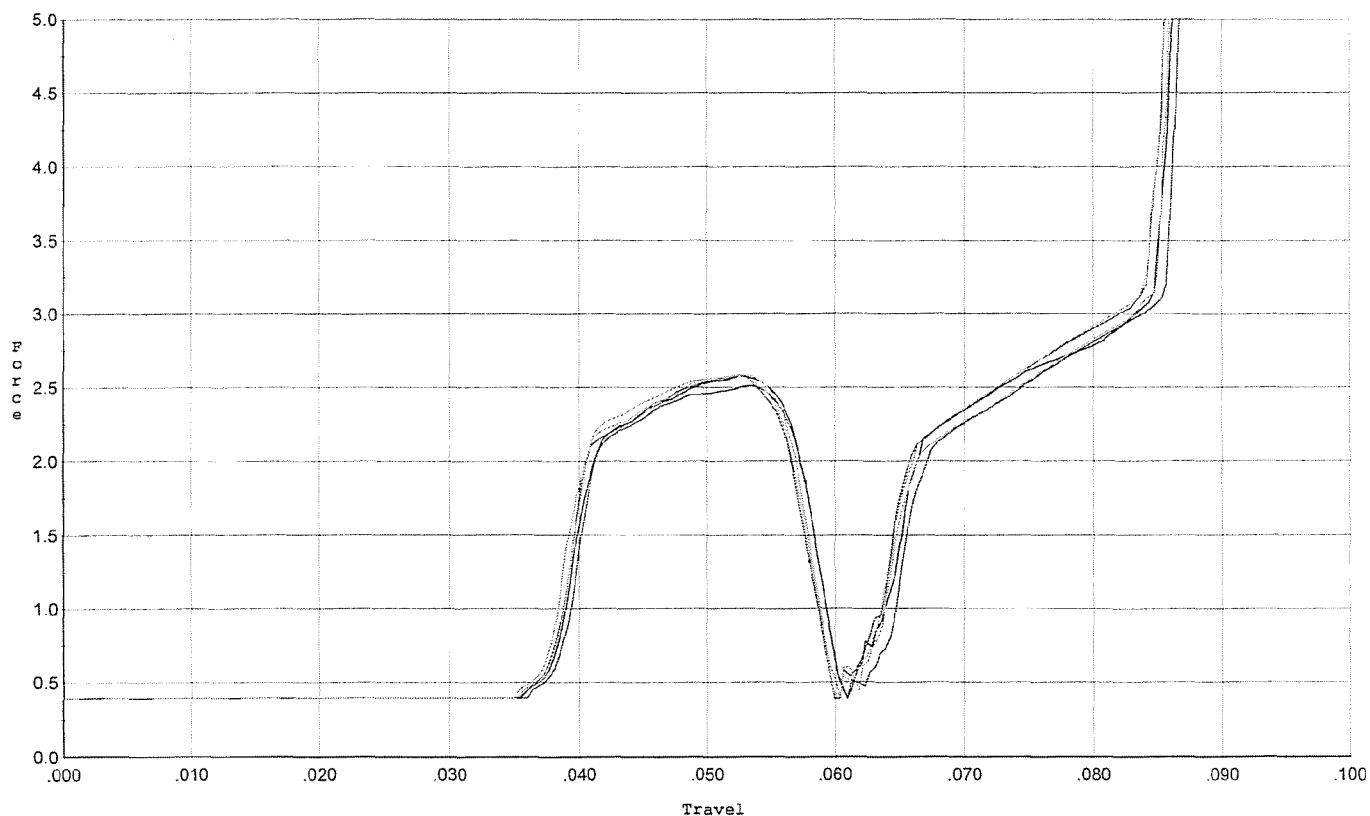
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.028	0.057	0.037	0.032	0.087		Set Trigger
2	3.980	0.059	0.035	0.032	0.089		Set Trigger
3	3.980	0.058	0.037	0.032	0.088		Set Trigger
4	3.980	0.058	0.036	0.032	0.088		Set Trigger
5	4.011	0.057	0.036	0.032	0.088		Set Trigger

Avg 3.99

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/13/08

Model: M/24
 Serial No: Form #F005
 Trigger: reset to 2.5 lbs. +/- .50 lbs. for final test



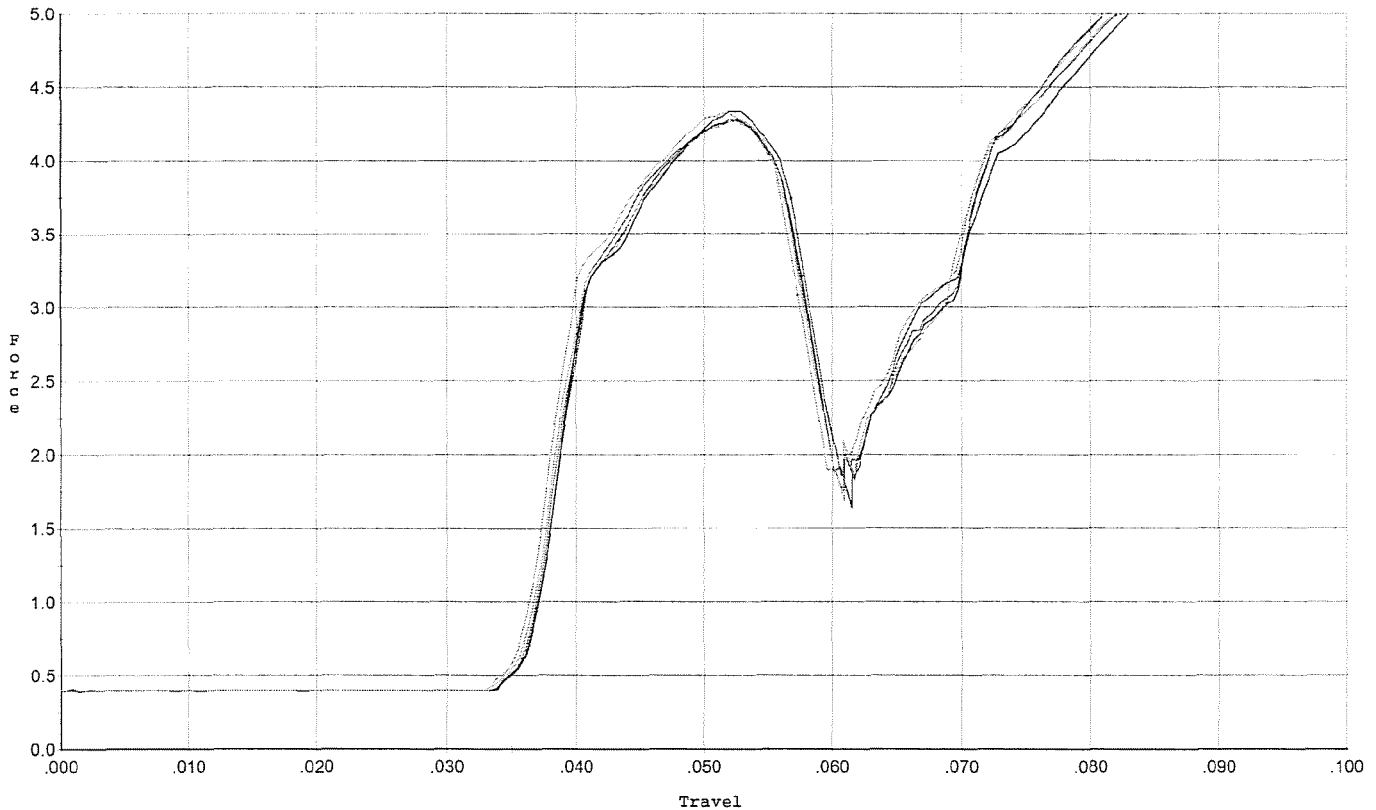
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.510	0.058	0.038	0.035	0.058		Set Trigger
2	2.579	0.058	0.038	0.035	0.059		Set Trigger
3	2.577	0.058	0.038	0.035	0.059		Set Trigger
4	2.580	0.057	0.038	0.035	0.059		Set Trigger
5	2.588	0.057	0.037	0.035	0.060		Set Trigger

Aug 2.56

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/13/08

Model: M/24
 Serial No: Form #F005
 Trigger: set to 4.0 lbs. +/- 1.0 lbs. for target & accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.333	0.057	0.034	0.032	0.089		Set Trigger
2	4.281	0.058	0.034	0.032	0.089		Set Trigger
3	4.281	0.058	0.036	0.032	0.091		Set Trigger
4	4.267	0.056	0.036	0.032	0.087		Set Trigger
5	4.327	0.057	0.035	0.032	0.091		Set Trigger

Avg 4.29